



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4635-141
Job Sheet 186159



Part No: D4635-141

Job Qty: 1 pcs

Part Name: Fwd Ceiling Replacement Panel Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/12/18

Job Tracking No:

Due Date: 12/7/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG D4635 REV F SHEET 9 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Doc Release DL IPP Rev. C Dwg. Update 13/07/09 DL ver:DD IPP Rev D Dwg Update 13/12/09 DL Ipp Rev. E Dwg Update 14/01/09 DL IPP Rev. F Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	12/7/18		0.00	1.47	Small Fab - 1		DAS 58 MAR 12 2019 9-89
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	12/7/18		0.00	0.00	QC 5 - 10		PD 19-03-13
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	12/7/18		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	58
				Packaging 3 - 8 - B4B	9-89 MAR 13 2019
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	12/7/18	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	MAR 13 2019 70

Part Op 110 - (Small Fab) Assemble as per Dwg D4635-141 Bond foam core to inside of panel 3M Scotch Weld 1300
 Descriptions: Batch: m131527 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # m138996 Expiry Date 07-19 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: m138961
 120 - QC5- Inspect part completeness to step on W/O
 130 - (Identify as per dwg & Stock Location: _____) Identify as per dwg & Stock Location: _____
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4635-1 <u>fg 234</u>	Fwd Ceiling Panel, LH	1 pcs (1 ea)	110-Small Fab - 1	<u>3131398</u>
D4669-1 <u>mfo04</u>	Bracket	2 Ea (2 ea)	110-Small Fab - 1	<u>5122230</u>
D4695-041 <u>fg 236</u>	Channel Assembly, LH	1 pcs (1 ea)	110-Small Fab - 1	<u>50225561</u>
D4732-29 <u>mfo05</u>	Label	1 pcs (1 ea)	110-Small Fab - 1	<u>5060906</u>
D4732-33 <u>mfo05</u>	Label	1 pcs (1 ea)	110-Small Fab - 1	<u>5060908</u>
D4732-5 <u>mfo05</u>	Label	1 pcs (1 ea)	110-Small Fab - 1	<u>5060826</u>
D4732-9 <u>mfo05</u>	Label	1 pcs (1 ea)	110-Small Fab - 1	<u>5130471</u>
D5022-1 <u>FG 236</u>	Foam, Side Panel, Fwd	1 pcs (1 ea)	110-Small Fab - 1	<u>5123667</u>
MPNY-750S-9-C <u>mfo04</u>	Mounting Pad	7 pcs (7 ea)	110-Small Fab - 1	<u>fm130423-1</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	D4635-1	1	4	0
	D4669-1	2	27	0
	D4695-041	1	4	0
	D4732-29	1	4	0
	D4732-33	1	4	0
	D4732-5	1	4	0
	D4732-9	1	14	0
	D5022-1	1	10	0
	MPNY-750S-9-C	7	152	0
Part Specifications				
Specifications could not be found.				

Plex 1/24/19 8:31 AM Dart.Hadley.Shannon



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D4635-141
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Part No: D4635-141

Job Qty: 1 ea

Part Name: Fwd Ceiling Replacement Panel Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/12/18

Job Tracking No:

Due Date: 12/7/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG D4635 REV F SHEET 9 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Doc Release DL IPP Rev. C Dwg. Update 13/07/09 DL ver: DD IPP Rev D Dwg Update 13/12/09 DL Ipp Rev. E Dwg Update 14/01/09 DL IPP Rev. F Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/7/18	0.00	0.00	Start Up Container		
110	Small Fab	1 pcs		12/7/18	0.00	1.47	Small Fab		
120	QC	1 pcs		12/7/18	0.00	0.00	QC5		
130	Packaging	1 pcs		12/7/18	0.00	0.00	Packaging3		
140	QC21-SA	1 Ea		12/7/18	0.00	0.00	QC21		

Part Op 110 - Assemble as per Dwg D4635-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Descriptions: Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: _____
120 - QC5- Inspect part completeness to step on W/O
130 - Identify as per dwg & Stock Location: _____
140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4635-1	Fwd Ceiling Panel, LH	1 Ea (1 ea)	90-Start up Operation	
D4669-1	Bracket	2 Ea (2 ea)	90-Start up Operation	
D4695-041	Channel Assembly, LH	1 Ea (1 ea)	90-Start up Operation	
D4732-29	Label	1 Ea (1 ea)	90-Start up Operation	
D4732-33	Label	1 Ea (1 ea)	90-Start up Operation	
D4732-5	Label	1 Ea (1 ea)	90-Start up Operation	
D4732-9	Label	1 Ea (1 ea)	90-Start up Operation	
D5022-1	Foam, Side Panel, Fwd	1 Ea (1 ea)	90-Start up Operation	
MPNY-750S-9-C	Mounting Pad	7 pcs (7 ea)	90-Start up Operation	

Job Allocations

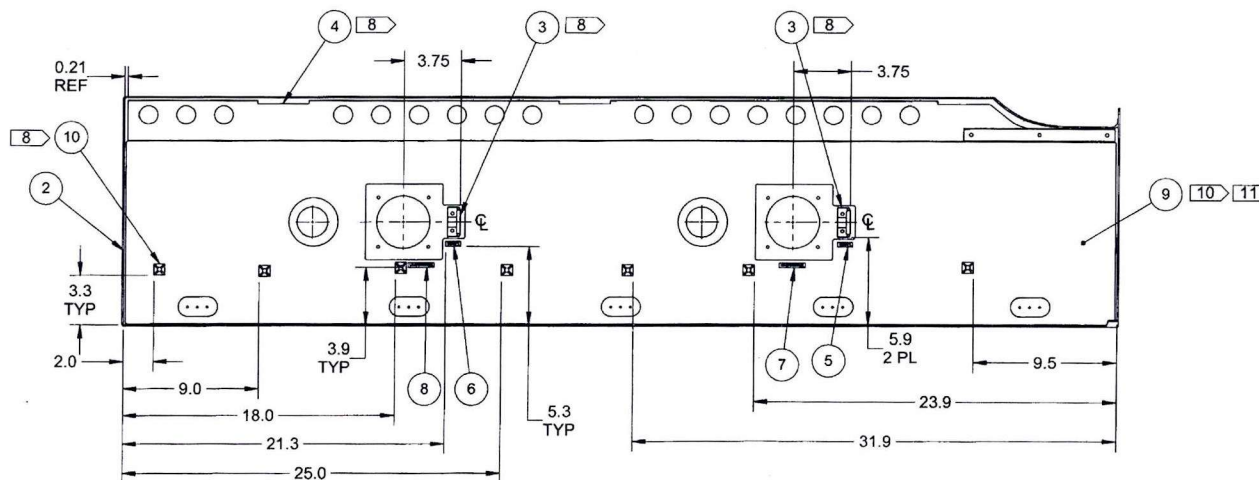
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4635-1	1	1	0
	D4669-1	2	34	0
	D4695-041	1	7	0
	D4732-29	1	6	0
	D4732-33	1	6	0
	D4732-5	1	6	0
	D4732-9	1	3	0
	D5022-1	1	5	0
	MPNY-750S-9-C	7	187	0

Part Specifications

Specifications could not be found.

Plex 11/12/18 11:45 AM dart.white.jesse

ITEM	QTY -141	P/N	DESCRIPTION
1	X	D4635-141	LH, FWD CEILING REPLACEMENT PANEL ASSY
2	1	D4635-1	LH, FWD CEILING PANEL
3	2	D4669-1	BRACKET
4	1	D4695-041	LH CHANNEL ASSEMBLY
5	1	D4732-5	LABEL
6	1	D4732-9	LABEL
7	1	D4732-29	LABEL
8	1	D4732-33	LABEL
9	1	D5022-1	FOAM, SIDE PANEL, FWD
10	7	MPNY-750S-9-C	MOUNTING PAD



D4635-141 LH, FWD CEILING REPLACEMENT PANEL ASSY

RELEASED

2015 JAN 26 *up*

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4669-1, D4695-041 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5022-1 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5022-1 FOAM ON D4635-1

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	DL	D4635	SHEET 9 OF 18
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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Container No: S161446

Part: D4635-141

Job No: 186159

Serial No/Batch: S161446

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/12/19